



Work Order ID 64428



Monday, December 06, 2010 8:55:10 AM

Page 1

Item ID: D3622-5

Accept



Setup



Revision ID:

Item Name: Ball Stud

Stop



Start Date: 12/6/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan:

RF

Date: 10/12/10

Tooling:

Date:

Run



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3622	C

100



Hardinge CNC LATHE SMALL

Hardinge

Hardinge CNC Lathe Small

Memo
1-TURN AS PER FOLIO F966 & DWG D3622,
FOLIO REV: *C*
DWG REV: *C*
2-DEBURR AS REQUIRED

SD 10/12/21

20 0

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

Memo

0.00

SD 10/12/21

20 0

120



QC8- Inspect parts - second check

0.00

QC

Quality Control

Memo

0.00

J. A 10/12/22

20 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64428

Monday, December 06, 2010 8:55:10 AM



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Item ID: D3622-5

Accept



Setup Start



Revision ID:

Item Name: Ball Stud

Stop



Start Date: 12/6/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 12/13/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: GTW

0.00

12/12/22 (20)

Packaging

Memo

0.00

Packaging

140



QC21- Final Inspection - Work Order Release

0.00

OK 12/12

QC

Memo

0.00

12/12/22 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, December 06, 2010 8:55:14 AM

Page 1

Work Order ID: 64428**Parent Item:** D3622-5**Parent Item Name:** Ball Stud**Start Date:** 12/6/2010**Required Date:** 12/13/2010**Start Qty:** 20.00**Required Qty:** 20.00**Comments:** IPP REV:A NEW ISSUE 10-09-23 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303H0.500 		Purchased	No			100	f	121.3480	0.108	2.23684 		<i>SDA</i>	<i>12/12/21</i>

303 HEX BAR .500

Location	Loc Qty	Loc Code
MAT037	121.348	
109778	99.548	
<i>109846</i>	21.8	<i>2-8 Pk</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

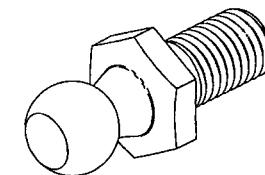
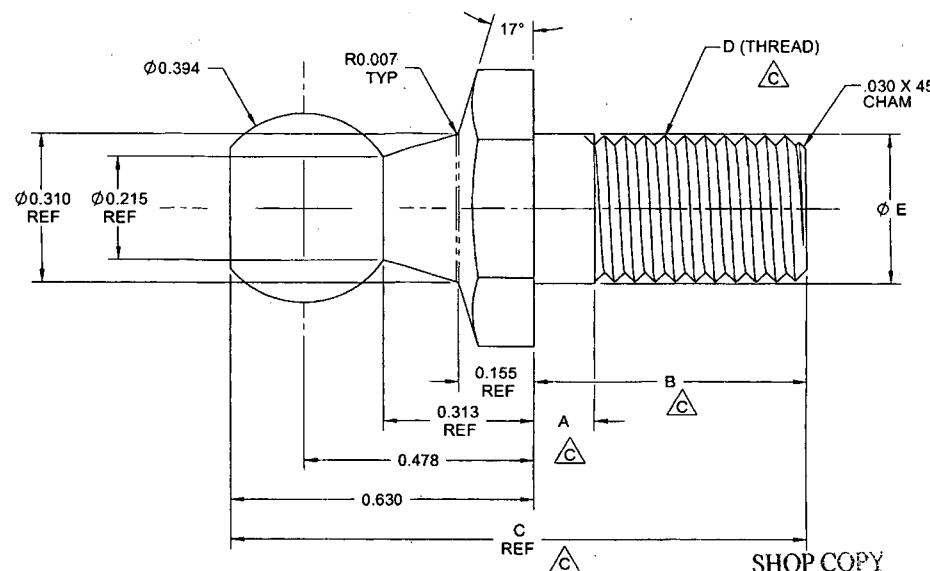
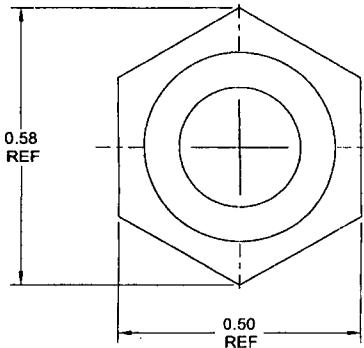
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

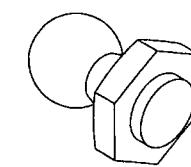
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3622-1 BALL STUD SHOWN



D3622-11 BALL STUD SHOWN

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. CL14128

28/10/12

RELEASED
2010-09-23

PART NUMBER	DIM A	DIM B	DIM C	WEIGHT (LBS)	THREAD D	Ø E MIN MAX
D3622-1	0.125	0.563	1.19	0.03	0.3125-24UNF-3A	0.3053 0.3125
D3622-3	0.125	0.563	1.19	0.03	0.1875-32UNF-3A	0.1840 0.1900
D3622-5	0.090	0.900	1.53	0.04	0.3125-24UNF-3A	0.3053 0.3125
D3622-7	0.060	0.330	0.96	0.03	0.3125-24UNF-3A	0.3053 0.3125
D3622-9	0.090	1.160	1.79	0.04	0.3125-24UNF-3A	0.3053 0.3125
D3622-11	0.060	N/A	0.69	0.02	NOT THREADED	0.270 0.300
D3622-13	0.090	0.680	1.31	0.03	0.3125-24UNF-3A	0.3053 0.3125

D3622-X BALL STUD

C

C	SHEET 1: ADD -5, -7, -8, -11 & -13. ADD D3622-X TABLE. SHEET 2 DELETED	JPH	10.07.20
B	ADD -3 (SHEET 2)	HS	09.09.18
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	D3622
MFG. APPR.		REV. C	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		BALL STUD	NTS
DATE	10.07.20	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE WHATSOEVER BY ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

NOTES:

- 1) MATERIAL: AISI 303 HEX BAR
REF DART SPEC M303H0.500
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D3622-X & B/N PER QSI 044
- 7) WEIGHT: SEE D3622-X TABLE

8 7 6 5 4 3 2 1

A

D

C

B

A

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	64428
Description: Bell 412	Part Number:	13622-5
Inspection Dwg: 18622 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>S. J.</u>	Audited by:	<u>J. A.</u>	Prototype Approval:	N/A
Date:	10/12/21	Date:	10/12/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	